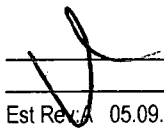
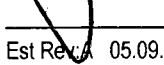


Next ASAP!

Dart Aerospace Ltd.

Date: Monday, 28/05/2007 9:07:10 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RING
Job Number	: 32408		
Estimate Number	: 10795		
P.O. Number	: N/A	Part Number	: D34131
This Issue	: 28/05/2007 S.O. No. : N/A	Drawing Number	: D3413 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	: 32408	Material	: N/A
Written By	: 	Due Date	: 04/06/2007
Checked & Approved By	: 	Qty:	20 Um: Each
Comment	: Est Rev: A 05.09.13 New issue KJ/JLM Est Rev: B Now on Waterjet 07-05-28 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3413

Dwg Rev: A

Prog Rev: A

M 07 06 22

20

2-Deburr if necessary

2.0	M304B0250X4000	304 BAR .250 x 4.00
-----	----------------	---------------------



Comment: Qty.: 0.2625 f(s)/Unit Total: 5.2500 f(s)

304 BAR .250 x 4.00

Batch: M104640

M 07 06 22

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 07 06 22

20

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/06/25

PC
→

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1.

MF 07-06-25

20

Date: Monday, 28/05/2007 9:07:10 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 32408

Part Number: D34131

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/26 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/M-07-06-26 (20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/06/27 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/06/27 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/06/29

Job Completion



U 07-06-28

(20)

23

Date: Wednesday, 5/16/2007 1:40:54 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING
 Job Number : 32408
 Estimate Number : 10795
 P.O. Number :
 This Issue : 5/16/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D34131
 First Issue : 1 / 1 Type : PURCHASED PARTS Drawing Number : D3413 REV A
 Previous Run : 24869 Project Number : N/A
 Material :
 Due Date : 6/4/2007 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : 07.05.16
 Comment : Est Rev: A 05.09.13 New issue KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: _____

Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3413

Possible Supplier: Industrial Laser

Material release note is required

*m304B: 250x4.0
 .25 F.*

WZ

2.0

D34131F

RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

RING

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1.

PTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-06-25	4.0	Ø. 266 ; one oversized due to the taper in the hole to Ø. 276.	ASIAWZ	Acceptable.	Up 07/06/25	07-06-25	ASIAWZ	07-06-25

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:40:54 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 32408

Part Number: D34131

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

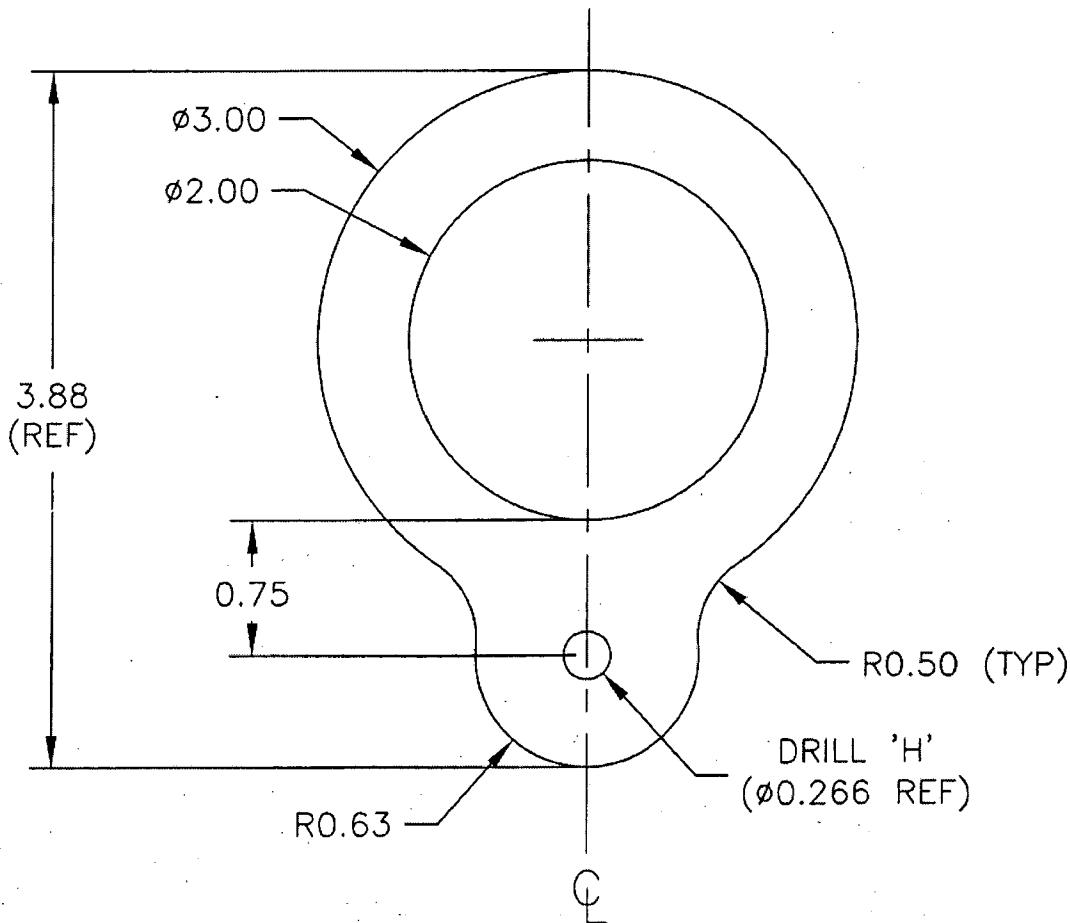
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06**D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. (M30455GA))
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32408

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DART AEROSPACE LTD		Work Order: 32408
Description: Ring		Part Number: D3413-1
Inspection Dwg: D3413	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.266$	+0.006-0.001	0.270	✓		VWV	
B $\phi 2.00$	+0.012-0.001	2.00	✓		VWV	
C $\phi 3.00$	+0.012-0.001	3.002	✓		VWV	
D 0.75	+/- 0.030	0.75	✓		VWV	
E 3.88	+/- 0.030	3.88	✓		VWV	
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ml. ml	Audited by: Ep	Prototype Approval: N/A
Date: 07 06 22	Date: 07 06 25	Date: N/A
Rev	Date	Change
		New Issue
		Revised by KJ/RF
		Approved